



Dart Hawkesbury
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D4634-141
Job Sheet 167074-I



Part No: D4634-141

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/23/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/23/17	0.00	0.00	Start up container	2017-12-14 29L
100	HandThermo	1 pcs		11/23/17	0.00	1.65	HandFinish4	17/12/18 49
110	Small Fab	1 pcs		11/24/17	0.00	1.47	Small Fab	17/12/18 15L
120	QC	1 pcs		11/24/17	0.00	0.00	QC5	
130	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging3	DEC 21 17-12-27
140	QC21-SA	1 Ea		11/24/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649- Expiry Date 18/01/19 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	- D4634-1 5019743	1	3	0	0
	- D4636-5 5021615	1	43	0	0
	- D4647-5 5021614	1	2	0	0
	- D4664-5 5021613	6	39	0	0
	- D4712-1 5021612	1	4	0	0
	- D4732-15 5021611	1	2	0	0
	- D4732-19 5021610	1	1	0	0
	- D5021-1 5017834	1	2	0	0
	- MPNY-750S-9-C 5021606	7	570	0	0
	- MS20426AD3-4 5021605	4	5,055	0	0
	- MS20426AD4-6 5021603	2	2,797	0	0
	- MS21059L08 5021591	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description: _____	DISPOSITION Rework ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>ig ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>ig ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>ib ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	ig ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	ig ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	ib ☐	Composite ☐	Supplier ☐	
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ib ☐	Composite ☐	Supplier ☐																	
		active : _____ Disposition _____ _____	MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																

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Mfg Date: 12/14/17
 Job No: 167074-I

Fwd, Center Ceiling Replacement Panel Assembly

D4634 - 141

Start up Operation

PART NO:
Revision:
Operation:
Change No:

Root Cause

Environment	☐	No
Design	☐	Op
Doc/Data	☐	Of
Equip/Tooling	☐	Su
Handling/Pre	☐	Tr
Material	☐	U
Internal Transport	☐	P
Tribal Knowledge	☐	R
LOA	☐	F
Substation	☐	P
Past Expiry Date	☐	Manufacturing Process
Misidentified	☐	Past Due

S021711

DART AEROSPACE

FAULT CATEGORY

/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
age/Defect ☐	Folio/Program ☐	Outside Dimensions ☐
complete/Unqualified ☐	Grain ☐	Over/Under tolerance ☐
on ☐	Weld ☐	Part Incorrect ☐
rt ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Incomplete/Unclear ☐	Out of Sequence ☐	Part Moved ☐
	Off-set ☐	Drawing ☐
	Mislabeled ☐	Finish ☐
	Fit/Function ☐	Misread ☐
	Misaligned/off center ☐	Turning Sequence ☐